

Work Order ID 90074

September-13-12 12:59:53 PM

90074

Page 1

Item ID: D3391-023

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Mid Tube Assembly

Start Date: 9/13/12 Start Qty: 1.00

1

Cust Item ID:

Required Date: 10/05/12 Req'd Qty: 1.00

1

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan: MLJ Date: 12-09-13 Tooling:

Date:

QC: Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3391	I
-------	---

100

0.00

100

Skidtubes

Skidtubes

Skidtubes

Memo

0.00

~~1~~ Cut tube to finish length as per Dwg D3391

~~2~~ Drill pilot holes using DT8796 (Do not drill "B" holes) and drill only 1 fwd saddle hole on one side only as per Dwg D3391

~~3~~ Open saddles and GHW holes to Ø0.375" except for fwd saddle hole of detail "J"

~~4~~ Remove .030" from Fwd indexing Ridge as per Dwg D3391

~~5~~ Remove indexing ridge on Fwd & Aft end of skidtube as per Dwg D3391

~~6~~ Deburr

~~7~~ Drill #30 pilot holes using wearplate Jig DT8217 Identify Ø0.250" holes with paint marker,
***DO NOT DRILL HOLES #3-19-20 FROM FWD END OF JIG

~~8~~ Open wearplate holes of D3391-023 assembly detail section G-G to Ø0.250" (10 holes) as per Dwg D3391

~~9~~ Open wearplate holes of D3391-023 assembly detail section H-H to Ø0.297" (20 holes) as per Dwg D3391

DO NOT OPEN 2 MOST FWD WEARPLATE HOLES

CF 12-10-22

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Item ID: D3391-023

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Mid Tube Assembly

Start Date: 9/13/12 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 10/05/12 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start *NR1*

QC: Date: SPC (Y/N): Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

10 Open .375" holes to .438" ***do not open fwd saddle holes***

11 Locate D3391-021 in D3391-023 at 9.00" (see view z-z)

12 Transfer drill one fwd saddle hole only to .188" dia, transfer drill all remaining fwd saddle holes using DT 8149 locating from previously drill .188" dia hole, using t-pins and clicos to ensure perfect allingment, open up previously tranfer drilled pilot holes in D3391-023/-021 to 0.438" dia. in D3391-021

13 Using DT8217, locating from two previously drilled holes, drill remaining wearplate holes into D3391-021.

14 Locating from two fwd wearplate holes in D3391-023 drill remaining 6 wearplte holes in D3391-021 using DT8937

15 Open 12 wearplate holes in D3391-021 to 0.297" dia.

16 Deburr and blow out all chips from inside tube, scribe batch # in D3391-023 at aft end.

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

(DAS 10)

10/10/23

CF 12-10-22

September-13-12 12:59:53 PM

Item ID: D3391-023

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Mid Tube Assembly

Start Date: 9/13/12 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 10/05/12 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

Run Start *NR1*

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

OC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID**Tool #****Plan
Code**

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

120

Chemical Conversion Coat per QSI005 4.1

0.00

120

Memo

0.00

HandFinish

Hand Finishing

130

QC7-Inspect Chemical Conversion Coat

0.00

130

Memo

0.00

QC

Quality Control

1 76 12-10-23

① SAD 12-10-24

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Item ID: D3391-023 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Mid Tube Assembly
 Start Date: 9/13/12 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 10/05/12 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Skid tubes	0.00							
140									
Skid tubes	Memo	0.00							
Skid tubes	1-Open float bag holes as per dwg 2-C'sink float bag holes as per dwg 3- Prepare tube for welding 4-Bond web in place as per Dwg D3391 & QSI 015. Adhere for 12 hours) A/R Sikaflex exp: 13-06-22 batch#: 7M124025 NOTE:ENSURE WEB IS INSERTED IN AFT END OF TUBE								
150	QC5- Inspect part completeness to step on W/O	0.00							
150									
QC	Memo	0.00							
Quality Control									

SAN
12-16-22

1 0 12-10-25 DAS 18 9-83

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Item ID: D3391-023 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Mid Tube Assembly
 Start Date: 9/13/12 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 10/05/12 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* Skidtubes	Skidtubes	0.00							
	Memo	0.00							
	1-Weld crossbolt spacer as per dwg D3391 & QSI 004			A/R M122357					#E12-10-25
	2-grind weld flush			→ CF 12-10-25					
170 *170* QC	QC10- Inspect visual per QSI004- ground welds	0.00							
	Memo	0.00							1x
	Quality Control								
180 *180* QC	QC5- Inspect part completeness to step on W/O	0.00							
	Memo	0.00							1x
	Quality Control								

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Item ID: D3391-023 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Mid Tube Assembly
 Start Date: 9/13/12 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 10/05/12 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
185	Pressure Wash per QSI005 4.3	0.00							
185									
HandFinish	Memo	0.00							
Hand Finishing	AND REALODINE AS PER PAR09-043								
190	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
190									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 3:40								
	OVEN TEMPERATURE: 320								
	FINISH TIME: 4:10								
200	QC3- Inspect Part Finish	0.00							
200									
QC	Memo	0.00							
Quality Control									

1 76 12.11.9
 1X 12/11/13
 1x 4 11 11/120

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Item ID: D3391-023 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Mid Tube Assembly
 Start Date: 9/13/12 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 10/05/12 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210		0.00							
210	Skidtubes								
Skidtubes	Memo	0.00							
Skidtubes	1- insert D3391-021 into D3391-23								
	2- insert T-pins into first and third fwd saddle holes								
	3- ON FIRST SIDE ONLY drill out 2nd and forth fwd saddles holes to 0.500" as per DSI 9364								
	4- remove T-pins and locate DT9415 from first and third crossbolt hole using T-pins and clekos								
	5- ON 2ND SIDE ONLY ream out 2nd and forth saddle hole to 0.499". Remove DT9415								
	6- deburr, re-alodine and blow out chips								
	7- press fit D3591-1 spacers using DT9416 starting from 0.500" side								
220	QC5- Inspect part completeness to step on W/O	0.00							
220									
QC	Memo	0.00							
Quality Control									

DAS 16 12/14/20

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Item ID: D3391-023 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Mid Tube Assembly
 Start Date: 9/13/12 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 10/05/12 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	HandFinishing	0.00							
230	HandFinish	0.00				1 x	0	11	11/11/20
Hand Finishing	✓ Memo Install Inserts as per Dwg								
240	QC5- Inspect part completeness to step on W/O	0.00							
240	QC	0.00							
Quality Control	Memo								
250	Identify as per dwg & Stock Location: <u>w10</u>	0.00							
250	Packaging	0.00							
Packaging	Memo								

68-6
91
(500)

12/11/20

0412-742-043/389934

1 x 0 11 11/11/20

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Item ID: D3391-023 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Mid Tube Assembly
Start Date: 9/13/12 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 10/05/12 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
260	QC21- Final Inspection - Work Order Release	0.00							
260									
QC	Memo	0.00							
Quality Control									

12/11/22 *MF*
12-11-21

Picklist Print

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Page 1

Work Order ID: 90074

Parent Item: D3391-023

Parent Item Name: Mid Tube Assembly

Start Date: 9/13/12

Required Date: 10/05/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP A05.10.20 New Issue KJ/EC
 IPP B06.02.10 ECN 773 dwg rev.D EC
 IPP C 07.03.20 rev F dwg EC
 IPP D 07.03.28 re-format EC
 IPP E 07.10.31 ecn 1053P EC
 IPP Rev:F ECN 1056 07-11-13 DD verified by: EC
 IPP Rev:G 08-09-08 new process (ecn 08-510) DD verified by:EC
 IPP Rev:H 08-09-10 revH as per dwg DD verified by:EC
 IPP Rev: I 08-11-13 Removed steps per w/o, QC KJ verified by: ec IPP Rev:J add in seq 140
 expire date & b# sikaflex DD 10.02.17 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2500-1-100 Skidtube Extrusion		Manufactured	No			100	Each	163.0000	1	1		CF 12-10-22	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				HALL		163							
				50251		3							
				82373		59							
				86065		101							
D3391-021 Fwd Tube Assembly		Manufactured	No			100	Each	0.0000	1	1		CF 12-10-22	
D3389-1 Web		Manufactured	No			140	Each	16.0000	1			SAD 12-10-24	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				LG		16							
				85508		8							
				85509		2							
				86687		6							

Picklist Print

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Work Order ID: 90074

Parent Item: D3391-023

Parent Item Name: Mid Tube Assembly

Start Date: 9/13/12

Required Date: 10/05/12

Start Qty: 1.00

Required Qty: 1.00

D3681-1
Spacer

Manufactured No

160

Each

38.0000

5

5

BE 12/10/25
287611 x5

Location

Loc Qty

Loc Code

LG	20	
80361	1	
85417	19	
LG001	18	
68958	2	
69893	2	
71845	2	
74874	1	
76004	1	
77501	2	
88502	8	

D3591-1
Bushing

Manufactured No

210

Each

69.0000

2

2

21 2 21/1/20

Location

Loc Qty

Loc Code

FP	5	
80377	4	
82027	1	
ST055	64	
57350	1	
83237	63	

B92873

x2

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Shop Packet Print

Page 2

Picklist Print

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Page 3

Work Order ID: 90074

Parent Item: D3391-023

Parent Item Name: Mid Tube Assembly

Start Date: 9/13/12

Required Date: 10/05/12

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-130

Purchased

No

230

Each

4,069.0000

20

20

20

Insert X

ALS4-1032-130

Location

Loc Qty

Loc Code

279

3000

122763

3000

ST280

205

119084

116

120671

89

ST281

724

120807

36

120837

8

122474

680

ST282

140

121269

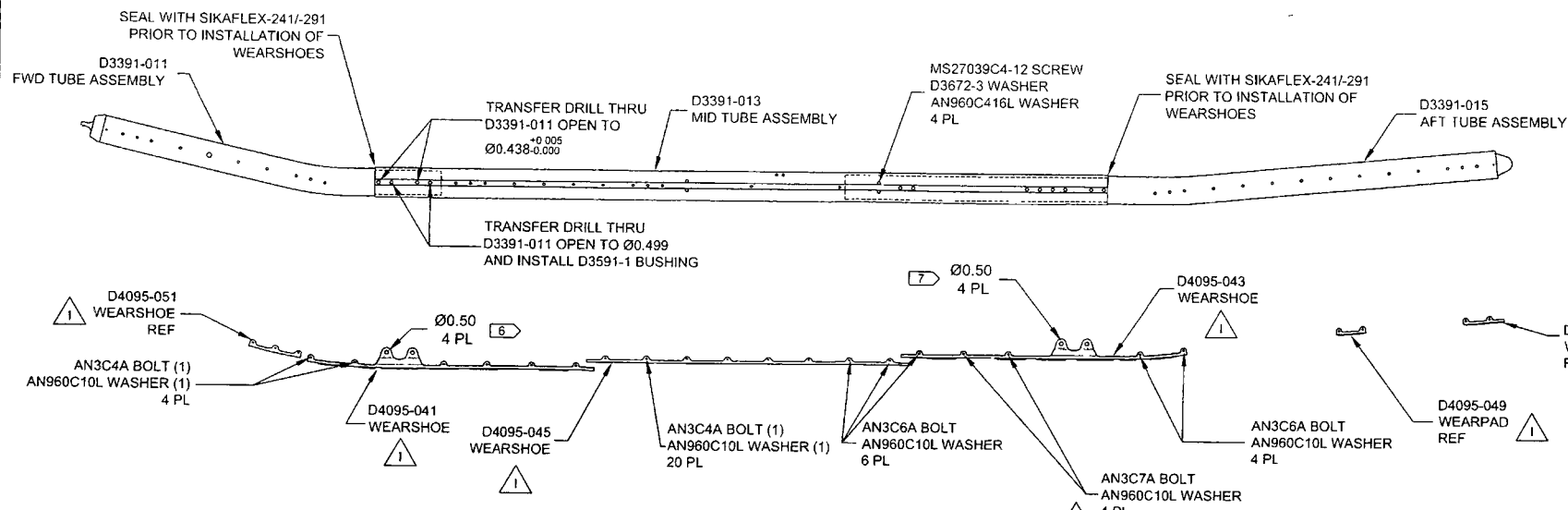
140

✓20

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Shop Packet Print

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D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY -041	PART NUMBER	DESCRIPTION
X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
1	D3391-011	FWD TUBE ASSEMBLY
1	D3391-013	MID TUBE ASSEMBLY
1	D3391-015	AFT TUBE ASSEMBLY
2	D3591-1	BUSHING
4	D3672-3	WASHER
1	D4095-041	WEARSHOE
1	D4095-043	WEARSHOE
1	D4095-045	WEARSHOE
1	D4095-047	WEARSHOE
1	D4095-049	WEARSHOE
1	D4095-051	WEARSHOE
24	AN3C4A	BOLT
10	AN3C6A	BOLT
4	AN3C7A	BOLT
38	AN960C10L	WASHER
4	MS27039C4-12	SCREW
4	AN960C416L	WASHER

GENERAL NOTES

- 1). FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON"
AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES
FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT
WHERE INDICATED.
- 6) FIT D4095-041 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH
APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND
TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-041
- 7) FIT D4095-043 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH
THE APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND
TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-043

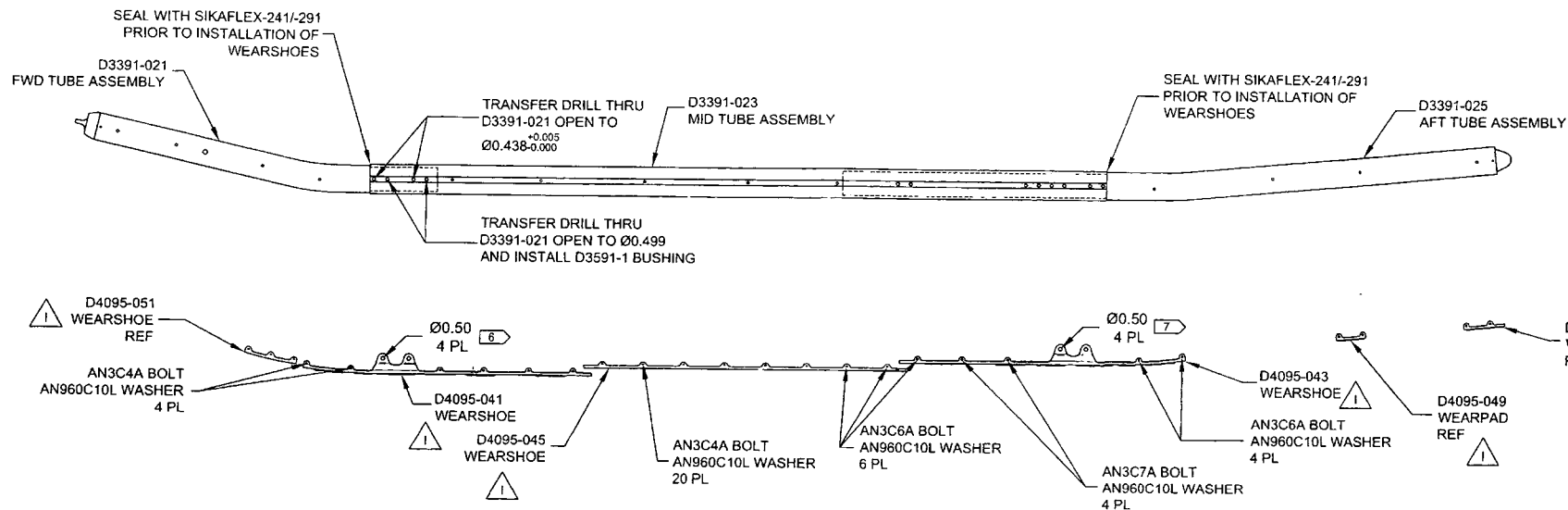
RELEASED
2011-11-04
ECN# 11-662

I	REMOVE GASKETS AND REPLACE ALL WEARSHOES: PARTS LIST UPDATE, ZN A8-1, ZN A8-2, ZN A8-4, ZN B6-8, LPS-3 COATING REMOVED FROM NOTE 2 ZN A3-1, ZN A3-2, REMOVED INSERT AELS-1032-130, ZN B6-4, B2-4, C7-8, C3-8, REMOVED HOLES, ZN D8-4 ZN D2-4, ZN D7-8, ZN D3-8	XDF	11.10.13
H	DRAWING UPDATED TO CURRENT STANDARDS. SHT 1 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. SHT 2 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. (FOR FURTHER INFO SEE DSI 9364 & NCR 08-074)	AJS	08.08.20
G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED		DRAWING NO.	REV. I
MFG. APPR.		D3391	SHEET 1 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	11.10.13	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC	

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WITHOUT NOTICE
WORK ORDER
NO. 90074 MLJ
12-09-13

90074



D3391-043 ASSEMBLY

D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY -043	PART NUMBER	DESCRIPTION
X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
2	D3591-1	BUSHING
1	D4095-041	WEARSHOE
1	D4095-043	WEARSHOE
1	D4095-045	WEARSHOE
1	D4095-047	WEARSHOE
1	D4095-049	WEARSHOE
1	D4095-051	WEARSHOE
24	AN3C4A	BOLT
10	AN3C6A	BOLT
4	AN3C7A	BOLT
38	AN960C10L	WASHER

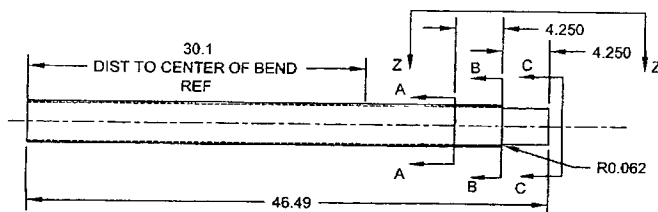
GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.
- 6) FIT D4095-041 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-041
- 7) FIT D4095-043 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH THE APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-043

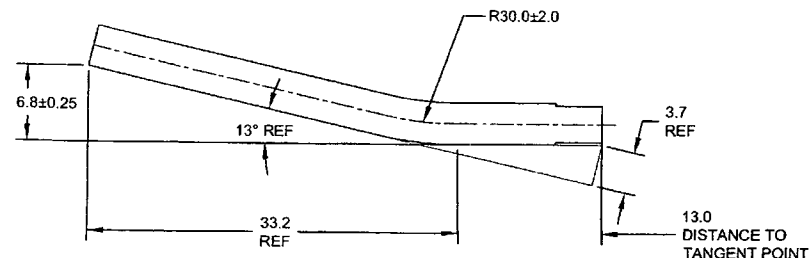
RELEASED
2011-11-04

DART AEROSPACE USA, INC			
DESIGN	PH	KENT, WA	
DRAWN	XDF		
CHECKED		DRAWING NO.	REV. 1
MFG. APPR.		D3391	SHEET 2 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	11.10.13	<small>COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC</small>	

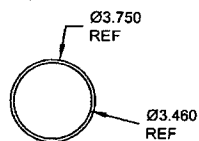
90074



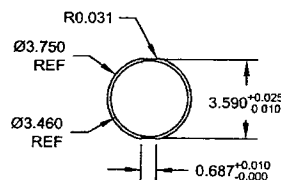
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



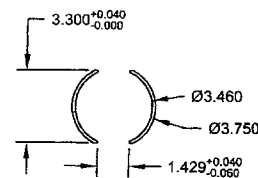
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



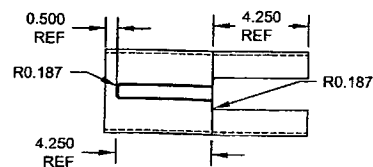
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SECTION B-B
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SECTION C-C
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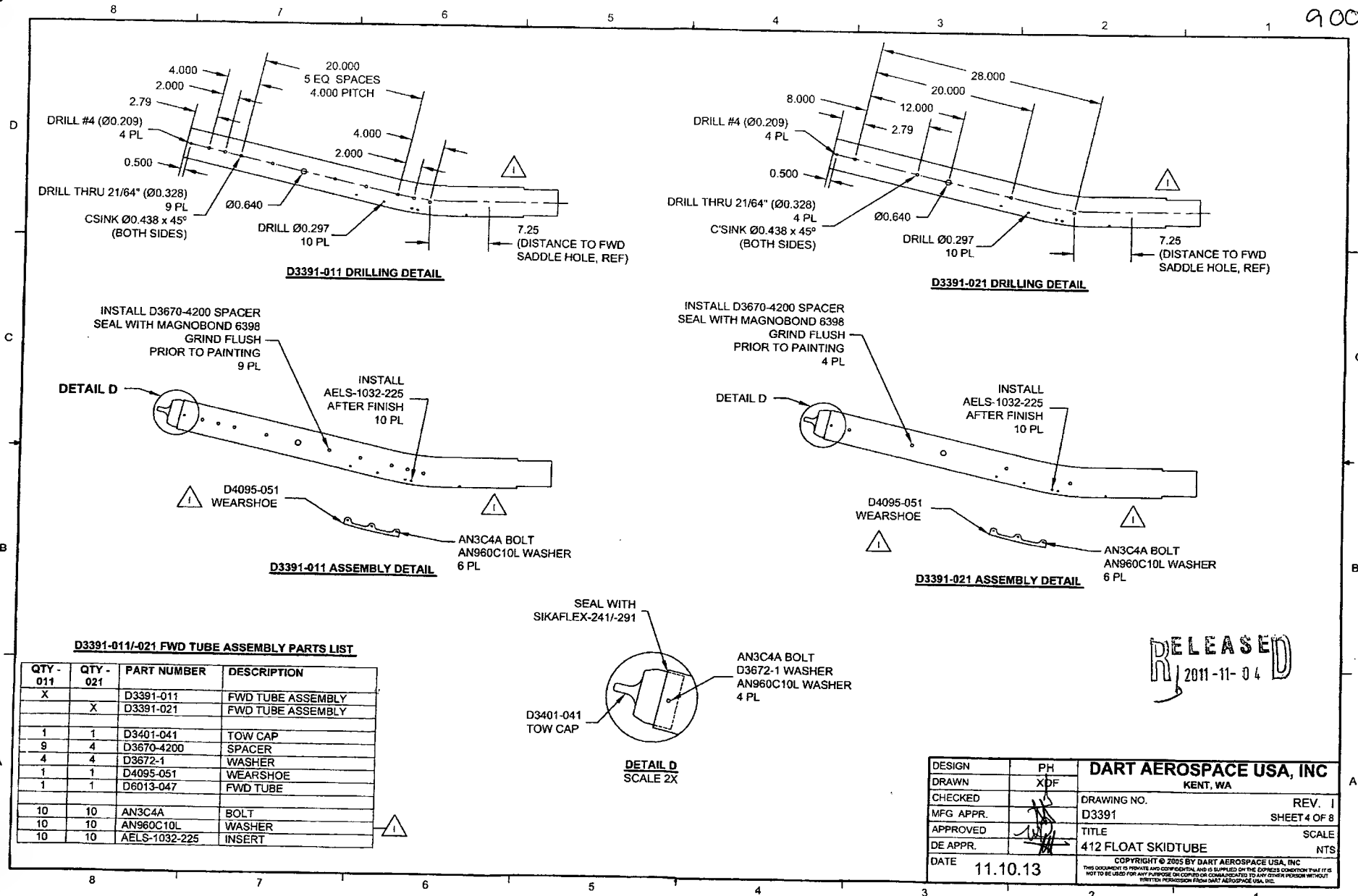


VIEW Z-Z
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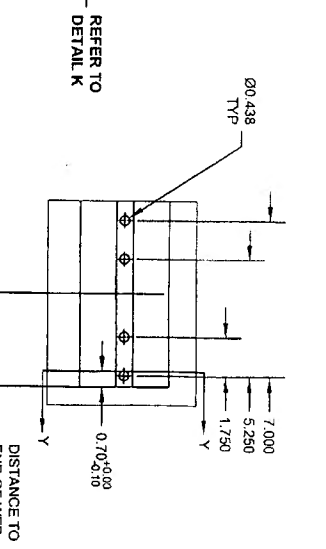
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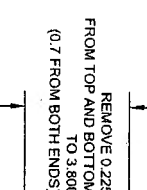
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DETAIL K
SCALE 4X

DETAIL K
SCALE 4X

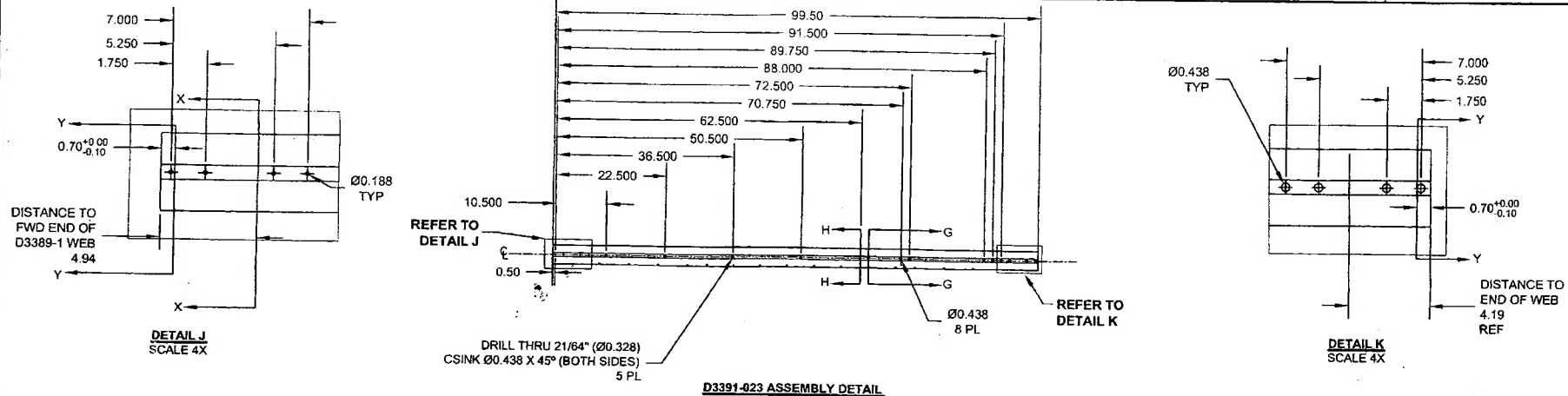


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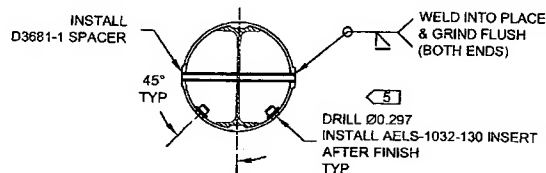
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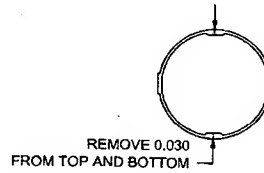
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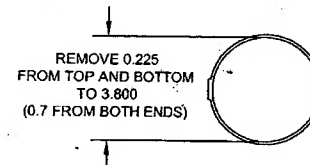
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SCALE 5X



SECTION H-H
SCALE 5X



SECTION X-X
SCALE 5X



SECTION Y-Y
SCALE 5X

D3391-023 MID TUBE ASSEMBLY PARTS LIST

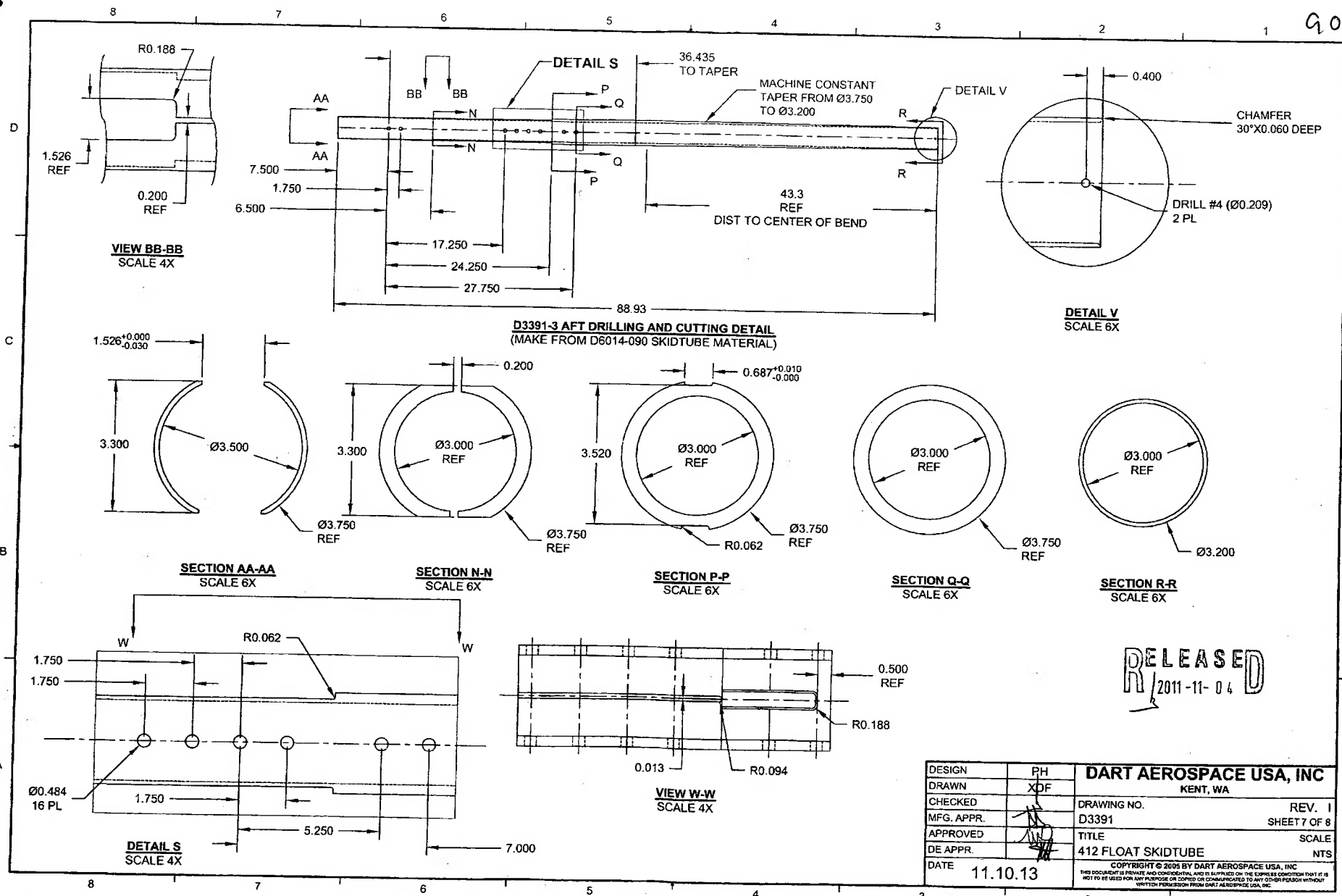
QTY - 023	PART NUMBER	DESCRIPTION
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT

D3391-023 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-291 PER QSI 015
- 3) WELDING: PER DART QSI 004

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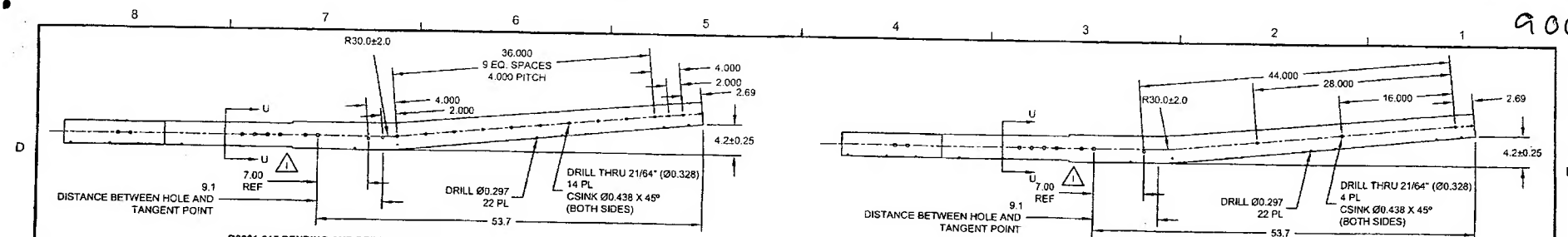
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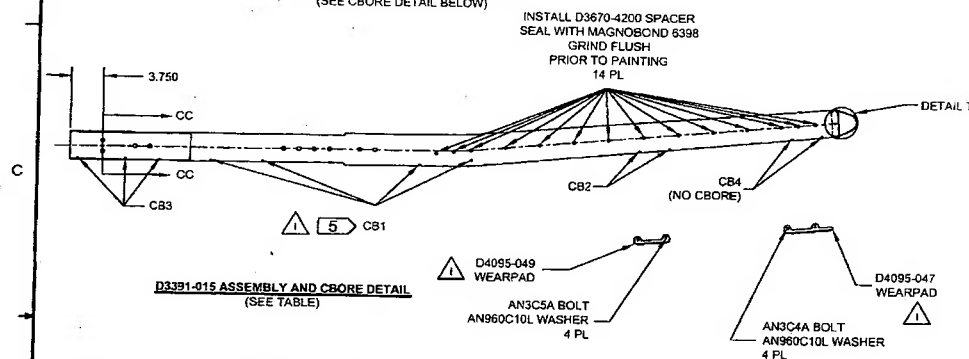
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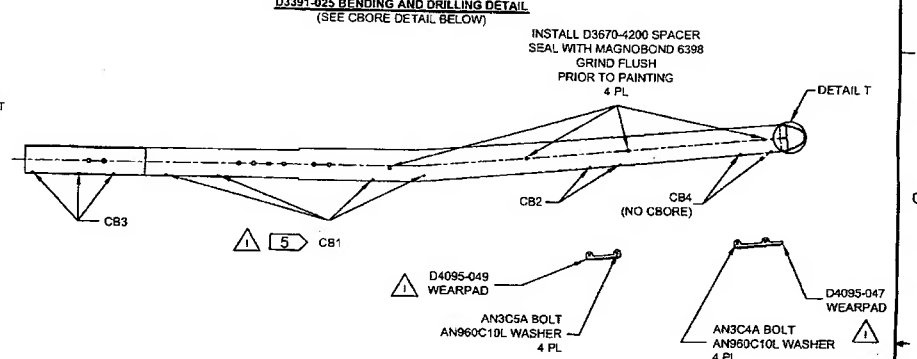


D3391-015 BENDING AND DRILLING DETAIL
(SEE CBORE DETAIL BELOW)

D3391-025 BENDING AND DRILLING DETAIL
(SEE CBORE DETAIL BELOW)



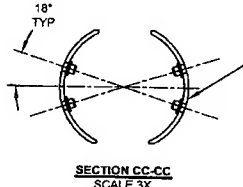
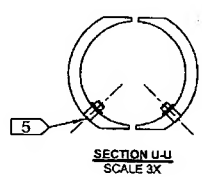
D3391-015 ASSEMBLY AND CBORE DETAIL
(SEE TABLE)



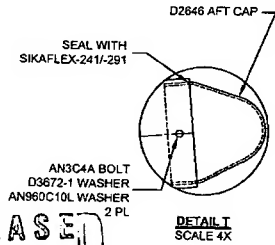
D3391-025 ASSEMBLY AND CBORE DETAIL
(SEE TABLE)

D3391-015/-025 AFT TUBE ASSEMBLY PARTS LIST

QTY - 015	QTY - 025	PART NUMBER	DESCRIPTION
X	X	D3391-015	AFT TUBE ASSEMBLY
		D3391-025	AFT TUBE ASSEMBLY
1	1	D2846	AFT CAP
14	4	D3670-4200	SPACER
2	2	D3672-1	WASHER
1	1	D4095-049	WEARPAD
1	1	D4095-047	WEARPAD
1	1	D6014-090	AFT TUBE
14	14	AELS-1032-130	INSERT
8	8	AELS-1032-225	INSERT
4	4	ALS4-428-165	INSERT
6	6	AN3C4A	BOLT
4	4	AN3C5A	BOLT
10	10	AN960C10L	WASHER



DRILL 0.391
CBORE 0.516 X 0.040 DEEP
INSTALL ALS4-428-165 INSERT
4 PL



CBORE HOLES MARKED CB1-CB4 AS FOLLOWS AND
INSTALL AELS-1032-XXX AFTER FINISH AS NOTED

HOLES MARKED	QTY D3391-015	QTY D3391-025	CBORE	P/N
CB1	8	8	0.430 X 0.170	AELS-1032-225
CB2	4	4	0.430 X 0.170	AELS-1032-130
CB3	6	6	0.430 X 0.040	AELS-1032-130
CB4	4	4	NONE	AELS-1032-130

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